

Work Order ID 100611-1

Wednesday, April 24, 2013 11:55:28 AM

100611

Page 1

Item ID: D3969-3

Revision ID:

Item Name: Spring (Basket Lid)

Start Date: 4/24/2013 Start Qty: 50.00 *50*

Required Date: 4/26/2013 Req'd Qty: 50.00 *50*

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NS1

Stop *NS2*

QC:

Date:

SPC (Y/N):

Date:

Stop

NR1

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3969

C

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 19683

Order as per Dwg D3969

Possible supplier: LS Technologies

part#: SSA4/8-122-310-360N

Material release note is required

13-04-24

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

20X

13-6-6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>						
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector		
Doc/Data	<input type="checkbox"/>													
Equip/Tooling	<input type="checkbox"/>													
Operator	<input type="checkbox"/>													
Material	<input type="checkbox"/>													
Setup	<input type="checkbox"/>													
Other	<input type="checkbox"/>													
Process	<input type="checkbox"/>													
Supplier	<input type="checkbox"/>													
Training	<input type="checkbox"/>													
Unapproved	<input type="checkbox"/>													
FAULT CATEGORY														
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
												<input type="checkbox"/> Other		

Work Order ID 100611

Wednesday, April 24, 2013 11:55:28 AM

100611

Page 2

Item ID: D3969-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Spring (Basket Lid)

Stop

NS2

Start Date: 4/24/2013 Start Qty: 50.00

50

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

AS
21
98
13-6-6

26

130

Identify as per dwg & Stock Location: 81262 0.00

0.00

130

Packaging

Packaging

Memo

0.00

26x

13-6-7

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

13-6-10

ME

13-6-10

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
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FAULT CATEGORY															
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												<input type="checkbox"/> Other			

Picklist Print

Page 1

Wednesday, April 24, 2013 11:55:33 AM

Work Order ID: 100611

Parent Item: D3969-3

Parent Item Name: Spring (Basket Lid)

100611
D3969-3

Start Date: 4/24/2013

Start Qty: 50.00

Required Date: 4/26/2013

Required Qty: 50.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per revC DD 10.03.16 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SSA4/8-122-310-360N		Purchased	No			110	Each	0.0000	1	50			

SSA4/8-122-310-360N

Gas Spring

**

26 x SP 13-6-6.

NCR: Yes / No

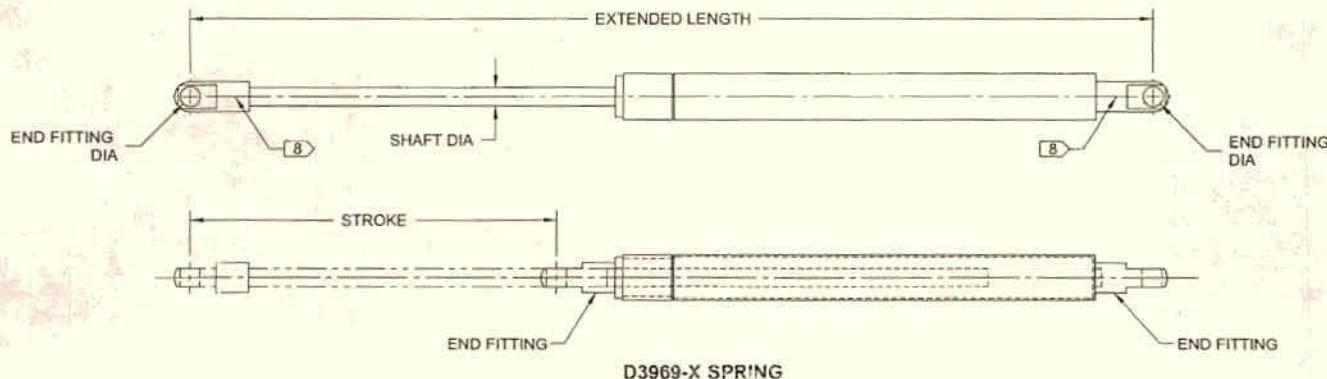
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
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Supplier	<input type="checkbox"/>														
Training	<input type="checkbox"/>														
Unapproved	<input type="checkbox"/>														
FAULT CATEGORY															
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												<input type="checkbox"/> Other			

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

RELEASED
R 2010-03-12
MP

C	REDRAWN IN SW. ADDED -3 & -5. ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs)	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID)	AJS	09.11.10
A	NOTE 8 ADDED.	AJS	09.07.27
REV.	NEW ISSUE		
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. C
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BASKET LID SPRING	
DATE	10.03.04	NTS	

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NOTES:
 1) MATERIAL: SEE CHART
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: SEE CHART
 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

LS TECHNOLOGIES INC

314 Jessop Ave
Saskatoon , SK S7N 1Y6

Ph # (306) 683-5000

Packing Slip

P.O. No.	Date	Invoice #
19683	6/04/2013	9931

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
5/09/2013		

Qty	Description
16	D3969-1 B100609 Stainless Gas Spring (SSA4/6-122-315-310N)
26	D3969-3 B100611 Stainless Gas Spring (SSA4/8-122-310-360N) Shipping Via FED EX Tracking # 799917013781

SP 13-6-6.



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

June 4, 2013

This is to certify that the parts listed below meets specifications as required by your order.

16 Units: D3969-1 B100609 Stainless Gas Spring (SSA4/6-122-315-310N)

26 Units : D3969-3 B100611 Stainless Gas Spring (SSA4/8-122-310-360N)

Country of Manufacture: Canada

Date of Manufacture : May 2013

This product is ROHS compliant.

Purchase Order # PO19683

Invoice # 9931

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read 'Nolan Fehr'.

Nolan Fehr
Manager



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19683

Purchase Order Date 4/24/2013

PO Print Date 4/24/2013

Page Number 1 of 1

Order From : VC-LST0001

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

Contact Name	Buyer	Brigitte Golden
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
Vendor Part Number							
1	SSA4/6-122-315-310N	Gas Spring	4/26/2013	20.00 Each	FedEx PI collect	\$65.0000	\$1,300.00
<i>McG</i>							
2	SSA4/8-122-310-360N	Gas Spring	4/26/2013	50.00 Each	FedEx PI collect	\$65.0000	\$3,250.00
<i>McG</i>							
<i>SP 13-6-6</i>							
PO Total:							\$4,550.00

Change Nbr: 1

Change Date: 4/24/2013

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO